

Work Order ID 71307

Tuesday, June 28, 2011 8:16:03 AM



Page 1

Item ID: D2873-045

Accept



Setup Start



Revision ID:

Item Name: Nut Plate Assembly

Stop



Start Date: 6/28/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 7/11/2011 Req'd Qty: 20.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 11-06-28

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2873

Rev A

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blanks: 1.000" x 0.375" x 2.700" long

cut 11/06/30

20

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Machine as per Folio FA and Dwg D2873 Identify as D2873-5
Dwg Rev *A* F1819Folio Rev *AA*

cut 11/07/05

20

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

cut 11/07/05

20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 71307

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Page 2

Item ID: D2873-045

Accept



Setup Start



Revision ID:

Stop



Item Name: Nut Plate Assembly

Start Date: 6/28/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 7/11/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

B.A 11/07/05

20

0

140

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

1-Deburr □2- C'sink as per Dwg D2873

EP 11/07/05 (20)

150

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/10/05

count
(x20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

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Setup Start

[illegible]

Stop

00000000000000000000000000000000

Cust Item ID:[illegible]

Customer:

Reference:

Run Start



Stop

[illegible]

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

0.00

1. The first group of respondents (10%) was made up of 100% females, 100% of whom were married. The mean age was 36.5 years, with a range of 25 to 45 years. The majority of respondents (80%) were employed, with 20% being unemployed. The majority of respondents (80%) were employed, with 20% being unemployed. The majority of respondents (80%) were employed, with 20% being unemployed.

0.00 δ 11/5/17

QC

Memo

Quality Control

Identify as per dwg & Stock Location: X-Tube

0.00

Ass'n

Packaging


Memo

Packaging

QC21- Final Inspection - Work Order Release

0.00

[illegible]

n/7/13 

QC

Memo

Quality Control

WME
11-07-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, June 28, 2011 8:16:09 AM

Page 1
T

Work Order ID: 71307



Parent Item: D2873-045



Parent Item Name: Nut Plate Assembly

Start Date: 6/28/2011

Required Date: 7/11/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP A 05.09.13 New issue KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS21075L5 Nut Plate		Purchased	No			100	Each	26.0000	2	40			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST303				26					
					116914			1					
					117557			25					
M6061T6B0.375X01.00 0 6061T6 BAR .375 x 1.00		Purchased	No			180	f	27.4166	0.225	4.736842			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				MAT002				27.4166					
					116963			7.4166					
				→ 117653				20					
MS20426AD4-6 Rivet		Purchased	No			180	Each	1,383.000	4	80			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST317				1383					
					110139			583					
					117505			800					

Handwritten: 6/30/12
M118267
40X

Handwritten: 4.74 ordered 30
6/30/12
80

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	71307
Description: Radius Block		Part Number:	D2873-5
Inspection Dwg: D2873 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.50	+/-0.030	2.500	—		Vern	ML-7
1.000	+/-0.010	1.000	—		"	"
0.750	+/-0.010	0.750	—		"	"
0.250	+/-0.010	0.250	—		"	"
1.000	+/-0.010	1.000	—		"	"
2.000	+/-0.010	2.000	—		"	"
Ø0.128	+0.005/-0.001	Ø0.130	—		"	"
0.359	+/-0.010	0.359	—		"	"
Ø0.316	+0.006/-0.001	Ø0.317	—		"	"
1.000	+/-0.010	1.004	—		"	"
0.250	+/-0.010	0.248	—		"	"
0.061	+/-0.010	0.065	—		"	"
Ø0.230 x 0.125	+0.005/-0.001 x 0.010	Ø0.230 x 0.128	—		"	"

Measured by:	amf	Audited by:	B.A	Prototype Approval:	N/A
Date:	11/07/05	Date:	11/07/05	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.08.30	New Issue P/O D2873-045	KJ/JLM	

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

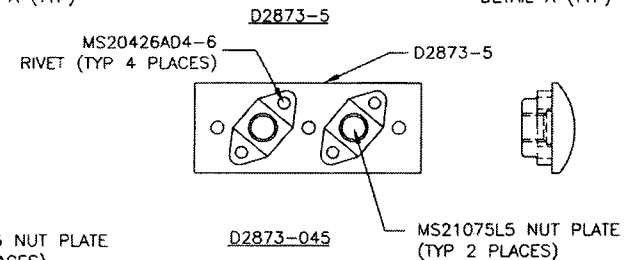
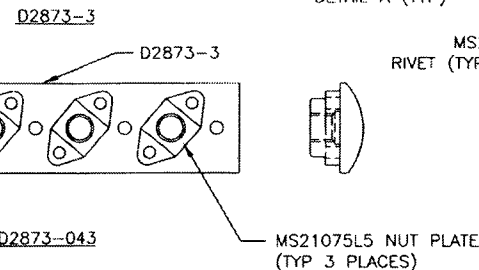
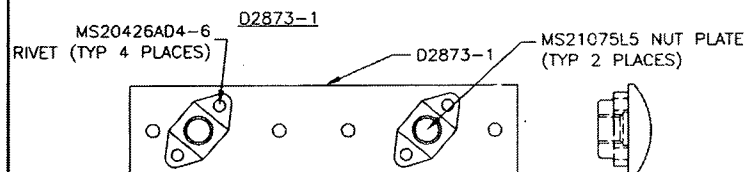
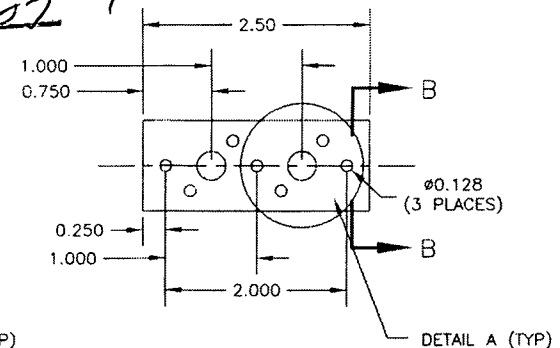
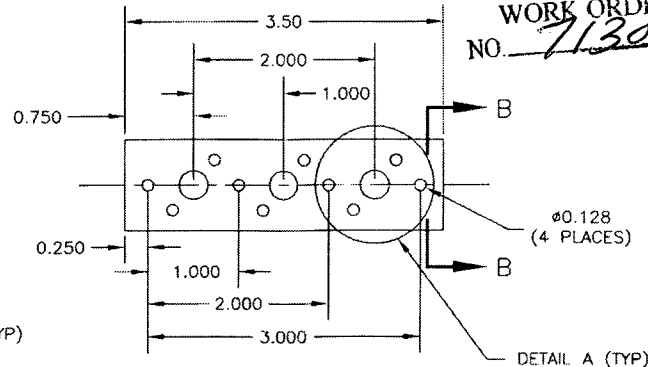
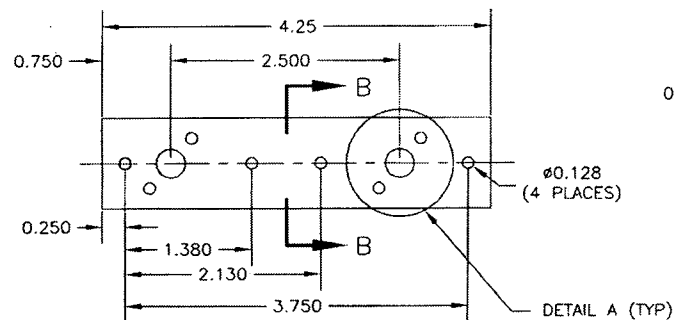
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER
NO. 71307

1106-28



D2873-041

MS20426AD4-6
RIVET (TYP 6 PLACES)

D2873-043

MS21075L5 NUT PLATE
(TYP 3 PLACES)

D2873-045

MS21075L5 NUT PLATE
(TYP 2 PLACES)

D2873-1/-3/-5 RADIUS BLOCK

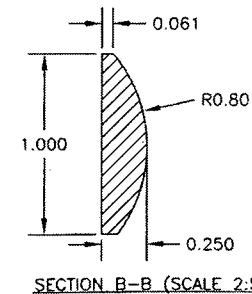
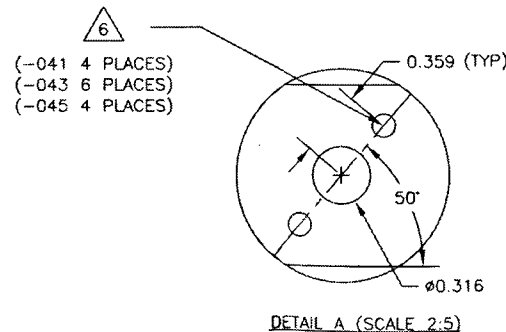
- 1) MATERIAL: 5052-H32/H34 BAR (QQ-A-225/7) (REF. DART SPEC M5052H32B1.000X0.250) OR 6061-T6 BAR (QQ-A-225/8 OR QQ-A-200/8) (REF. DART SPEC M6061T6B1.000X0.250)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 6) Ø0.128 PILOT + C'BORE CURVED SIDE Ø0.230X0.125 DEEP + C'SINK CURVED SIDE Ø0.225 x 100°

D2873-041/-043/-045 NUT PLATE ASSEMBLY

- 1) INSTALL MS21075L5 NUT PLATE IN ORIENTATION SHOWN USING MS20426AD4-6 RIVETS

D2873-041/-043/-045 NUT PLATE ASSEMBLY PARTS LIST

-041	-043	-045	PART NUMBER	DESCRIPTION
X			D2873-041	NUT PLATE ASSEMBLY
	X		D2873-043	NUT PLATE ASSEMBLY
		X	D2873-045	NUT PLATE ASSEMBLY
1			D2873-1	RADIUS BLOCK
	1		D2873-3	RADIUS BLOCK
		1	D2873-5	RADIUS BLOCK
4	6	4	MS20426AD4-6	RIVET
2	3	2	MS21075L5	NUT PLATE



RELEASED
05-07-26

A	05.07.26	NEW ISSUE
DESIGN	PH	DRAWN BY PH
CHECKED DS	APPROVED DS	DRAWING NO. D2873
DATE 05.07.26	TITLE RADIUS BLOCK	REV. A SHEET 1 OF 1 SCALE 4:5

W/O:		WORK ORDER CHANGES					
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